

Ship today 06/01

Work Order ID 64959

January 5, 2011 8:51:03 AM



PRELIMINARY ISSUE

Page 1

Item ID: D4313-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Exhaust Duct

Start Date: 1/05/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/05/11 Req'd Qty: 1.00

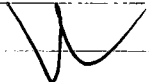


Customer:

Reference:

Run Start



Approvals: Process Plan: 

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4313

PA1

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut per drwg D4313 Rev PA1

B 11-1-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

 RD job
u

Work Order ID 64959

January 5, 2011 8:51:03 AM



Page 2

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Cust Item ID:

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Customer:

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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Small Fab

Memo

0.00

Small Fab

roll per drwg D4313 Rev PA1

SB 10/01/05

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

RD job
h

150

0.00



Large Fab

Memo

0.00

Large Fab

Weld per drwg D4313 Rev PA

M 114649

SB 11/01/04 (1x)

Work Order ID 64959

January 5, 2011 8:51:04 AM



Page 3

Item ID: D4313-1

Accept



Setup Start



Revision ID:

Item Name: Exhaust Duct

Stop



Start Date: 1/05/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/05/11 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

PC 11.01.06

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

- inspect to PAI Dry only
8/10/10/06

(10)

180



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

LD1332
per Hawley
11.01.05

11/01/06 (1)

Work Order ID 64959

January 5, 2011 8:51:04 AM

Page 4

Item ID: D4313-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Exhaust Duct

Start Date: 1/05/11 Start Qty: 1.00

Cust Item ID:

Required Date: 1/05/11 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u 11-01.06

Picklist Print

January 5, 2011 8:51:02 AM

Page 1

Work Order ID: 64959



Parent Item: D4313-1



Parent Item Name: Exhaust Duct

Start Date: 1/05/11

Required Date: 1/05/11

Start Qty: 1.00

Required Qty: 1.00

Comments: New Issue 11/01/05 Rev PA1

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased	No				sf	184.0714	2.55	2.55			



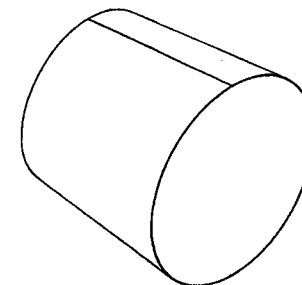
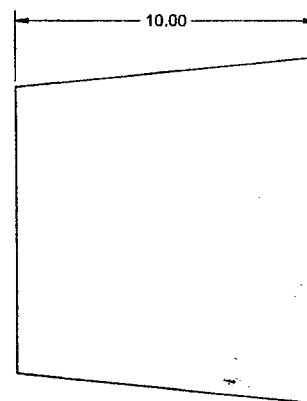
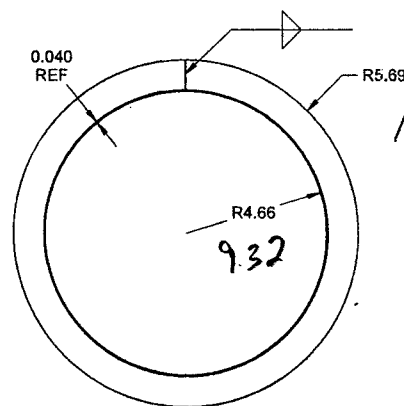
304/316 .040 Sheet



B 11-1-5

Location	Loc Qty	Loc Code
MAT	181.3	
115762	10.2	
115953	11.1	
116437	160	
MAT20	2.7714	
113062	1.398	
115440	1.3734	

116437



D4313-1 EXHAUST DUCT

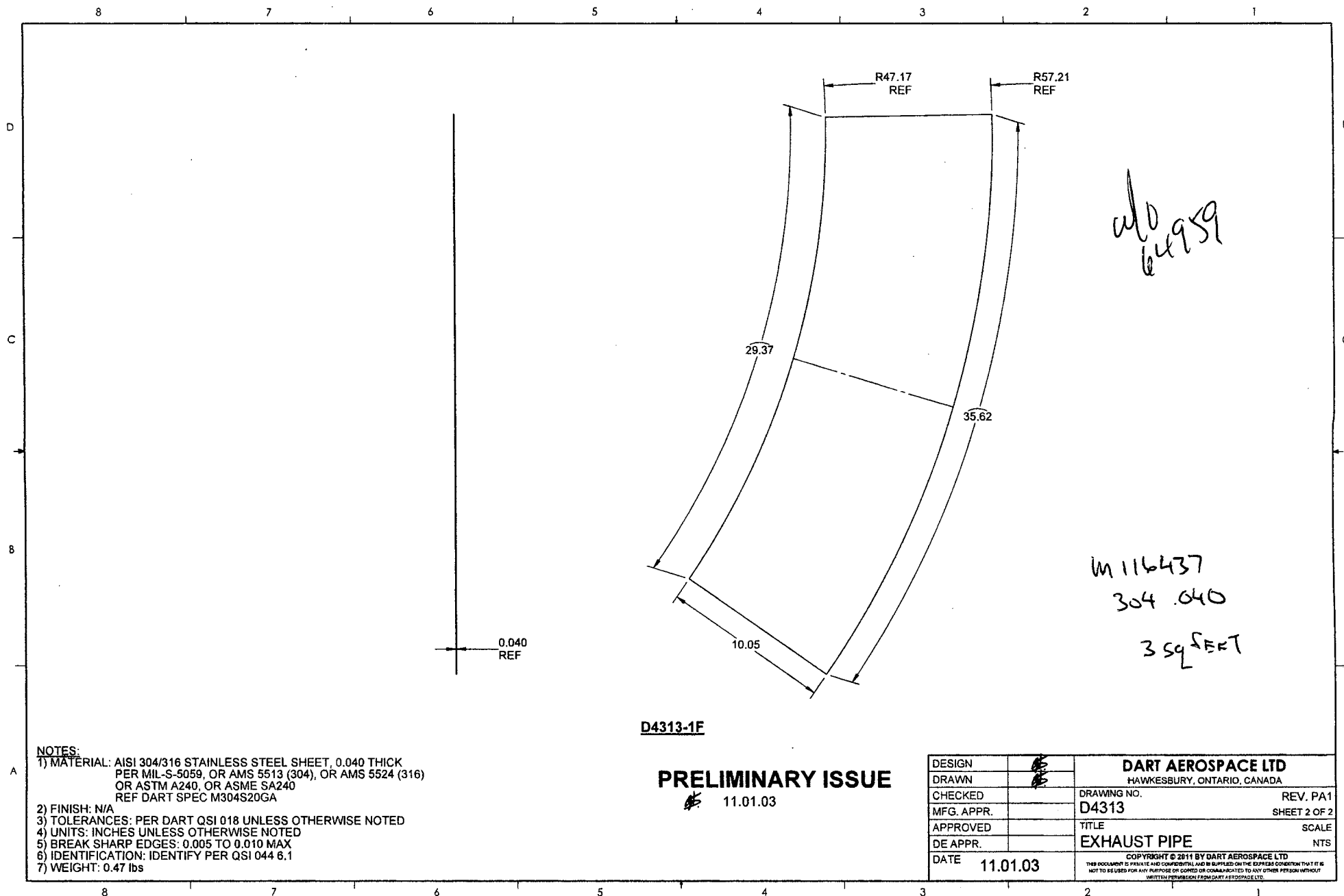
PRELIMINARY ISSUE

11.01.03

NOTES:

- 1) MATERIAL: MADE FROM D4313-1F
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.47 lbs

PA1	NEW ISSUE		11.01.03
REV.		DESCRIPTION	BY DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4313	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EXHAUST PIPE	NTS
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D4313-1F

PRELIMINARY ISSUE

11.01.03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059, OR AMS 5513 (304), OR AMS 5524 (316)
OR ASTM A240, OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.47 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA1
MFG. APPR.		D4313	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		EXHAUST PIPE	NTS
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